

# Work Order ID 71810

Tuesday, July 12, 2011 12:06:11 PM



Page 1

Item ID: D4017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly (350 )

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

JMF

Date: 11-07-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4017

C

100

Weld per dwg A/R S.S. rod Batch: M115778 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4017 using DT9610B  
\*\*\*inspect before welding mesh\*\*\*  
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary  
and trim to clear fasteners holes on the ends  
3- weld hinge (3) and Mounting brackets as per dwg D4017  
\*\*\*take lid to locate hinge and bracket\*\*\*

11.07.12

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.07.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Tuesday, July 12, 2011 12:06:11 PM



Page 2

Item ID:	D4017-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Short Basket Base Assembly (350 )				Stop	
Start Date:	7/12/2011	Start Qty:	1.00			
Required Date:	7/22/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00		8/10/2/13		40			
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

1 BR 11-7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Accept**



**Setup Start**



**Stop**



**Item Name:** Short Basket Base Assembly (350 )

**Start Date:** 7/12/2011      **Start Qty:** 1.00

**Cust Item ID:**

**Required Date: 7/22/2011      Req'd Qty: 1.00**



**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**



## Insp. Stamp

0.00



**Powdercoat**

**Memo**

0.00

## Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME:

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME:

140

### QC3- Inspect Part Finish

0.00



QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 12, 2011 12:06:11 PM



Page 4

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Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

9/5/11/07/20 ①

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/12

①

170

Identify as per dwg & Stock Location: G.A

0.00



Packaging

Memo

0.00

Packaging

w/o  
71809

9/5/11/07/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 71810**

Tuesday, July 12, 2011 12:06:11 PM



Page 5

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Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/7/20 [Signature]  
ME  
11-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, July 12, 2011 12:06:07 PM

Page 1

Work Order ID: 71810

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4017-1 Rib		Manufactured	No			100	Each	5.0000	1	1		11.07.15	
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA006	5	
8394	2	
68481	3	

D4018-1 Rib		Manufactured	No				Each	4.0000	1	1		11.07.15	
----------------	--	--------------	----	--	--	--	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	2	
67039	2	
WA005	2	
69077	2	

\*\*\*D4018-1 is the same as D4017-3\*\*\*

D4017-5 Hinge Rib		Manufactured	No			100	Each	6.0000	1	1		11.07.15	
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	6	
68480	2	
71106	4	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 12, 2011 12:06:07 PM

Page 2

Work Order ID: 71810

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100 Each

4.0000

1

1



Rib

Location

Loc Qty

Loc Code

WA

4

69730

1

71105

3

D4017-9

Manufactured No

100 Each

6.0000

2

2



Rib

Location

Loc Qty

Loc Code

WA

6

70341

6

D3916-041

Manufactured No

100 Each

4.0000

2

2



Rib Assembly

Location

Loc Qty

Loc Code

WA

4

69161

4

D3916-5

Manufactured No

100 Each

15.0000

1

1



Light Rib

Location

Loc Qty

Loc Code

WA

15

59088

5

69076

10

Tuesday, July 12, 2011 12:06:08 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 12, 2011 12:06:08 PM

Work Order ID: 71810

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4034-041 Manufactured No

100 Each

3.0000

1

1



Aft Upper Rib Assembly

B71483

①



11.07.15

Location

Loc Qty

Loc Code

WA006

3

69157

3

D4034-043 Manufactured No

100 Each

2.0000

1

1



Fwd Upper Rib Assembly

B71955 ①



11.07.15

Location

Loc Qty

Loc Code

WA006

2

70241

2

D2581 Manufactured No

100 Each

83.0000

2

2



Mounting Bracket



11.07.15

Location

Loc Qty

Loc Code

WA

83

69258

28

69739

4

90766

51

D3913-15 Manufactured No

100 Each

11.0000

1

1



Wide Handle Plate



11.07.15

Location

Loc Qty

Loc Code

WA

8

69158

4

69647

4

WA005

3

69012

3

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 12, 2011 12:06:08 PM

Page 4

Work Order ID: 71810

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-1 Manufactured No

100

Each

25.0000

3

3



Hinge Half, Base

Location

Loc Qty

Loc Code

WA

25

66418

0

68426

7

70342

18

D4020-3 Manufactured No

100

Each

0.0000

1

1



Mesh (350 Basket Short, Base)

D4020-11 Manufactured No

100

Each

6.0000

2

2



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

6

69648

6

D4021-1 Manufactured No

100

Each

45.0000

3

3



Handle Plate

Location

Loc Qty

Loc Code

WA

45

69518

8

69777

37

D2931 Manufactured No

150

Each

628.0000

2

2



Bumper

Location

Loc Qty

Loc Code

ST504

628

46064

628

Tuesday, July 12, 2011 12:06:08 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 12, 2011 12:06:08 PM

Page 5

Work Order ID: 71810

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

19.0000

2

2



Blanking Plate



*EP 11/07/20*

*2*

Location

Loc Qty

Loc Code

GA

17

70349

17

WA005

2

67008

2

AN3-10A Purchased No

150 Each

160.0000

6

6



Bolt



*EP 11/07/20*

Location

Loc Qty

Loc Code

ST351

160

117313

32

117795

128

AN960JD8 NAS1149DN832J Purchased No

150 Each

0.0000

2

2



Washer

*4 M117316 (2x)*



*EP 11/07/20*

MS20600-AD4W3 Purchased No

150 Each

893.0000

2

2



Cherry Rivets



*EP 11/07/20*

*2*

Location

Loc Qty

Loc Code

ST321

760

111636

112

117505

494

117601

154

WA018

133

107939

133

Tuesday, July 12, 2011 12:06:08 PM

Shop Packet Print

Page 5

**Dart Aerospace Ltd**

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Page 6

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,749.000

6

6



Nut



*EP 11/07/20*

Location

Loc Qty

Loc Code

ST300

1749

116549

89

117441

800

117601

400

117885

460

6

NAS1149F0332P

Purchased

No

150

Each

170.0000

12

12



WASHER



*EP 11/07/20*

Location

Loc Qty

Loc Code

ST275

170

117735

160

17317

10

12

Tuesday, July 12, 2011 12:06:08 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

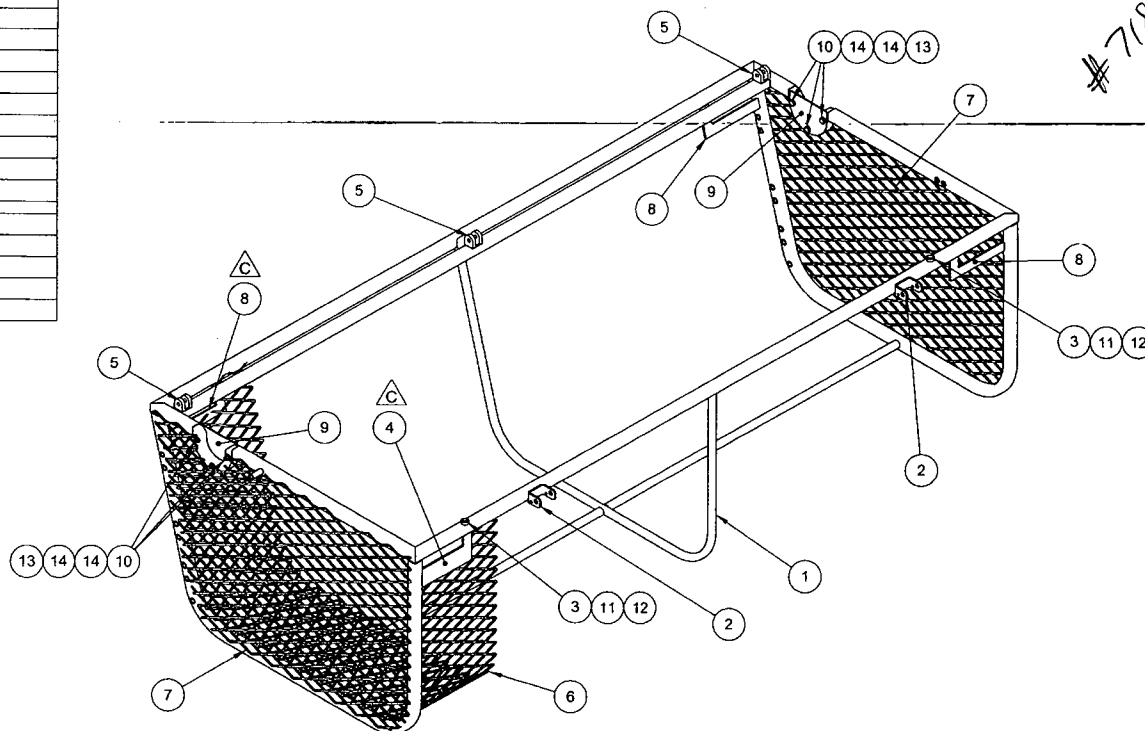
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596  
**RELEASED**  
10.08.12

**NOTES:**

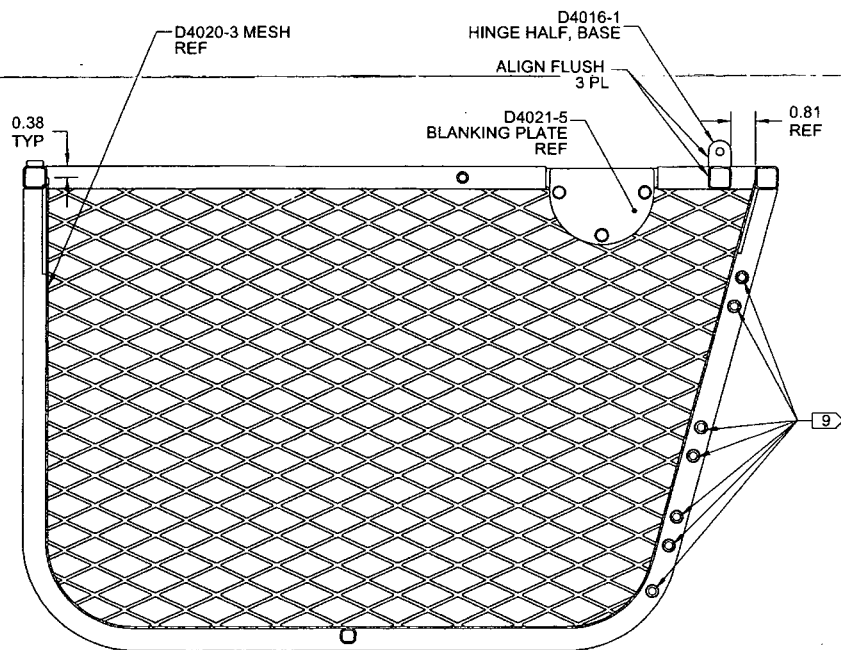
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D8-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	J.F.S.	D4017	SHEET 1 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SHORT BASKET BASE ASSY (350) _NTS	
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

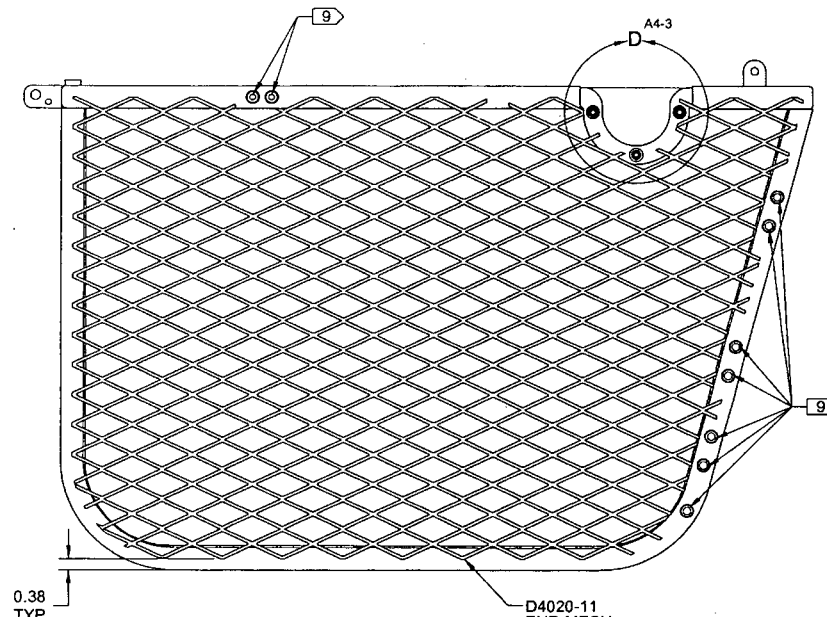




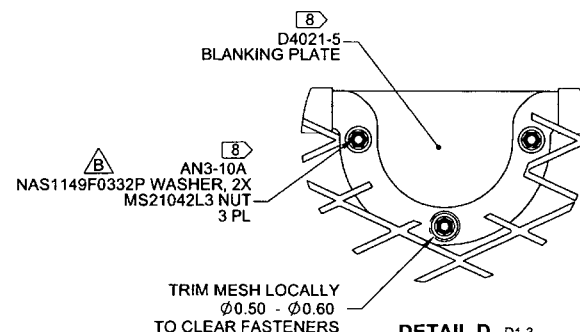
71810



SECTION A-A A5-2



SECTION B-B A2-2

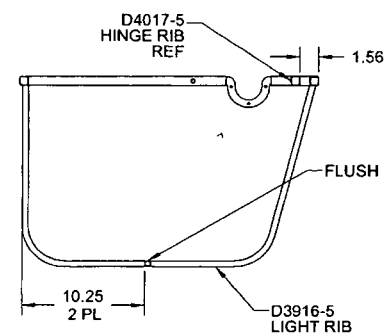
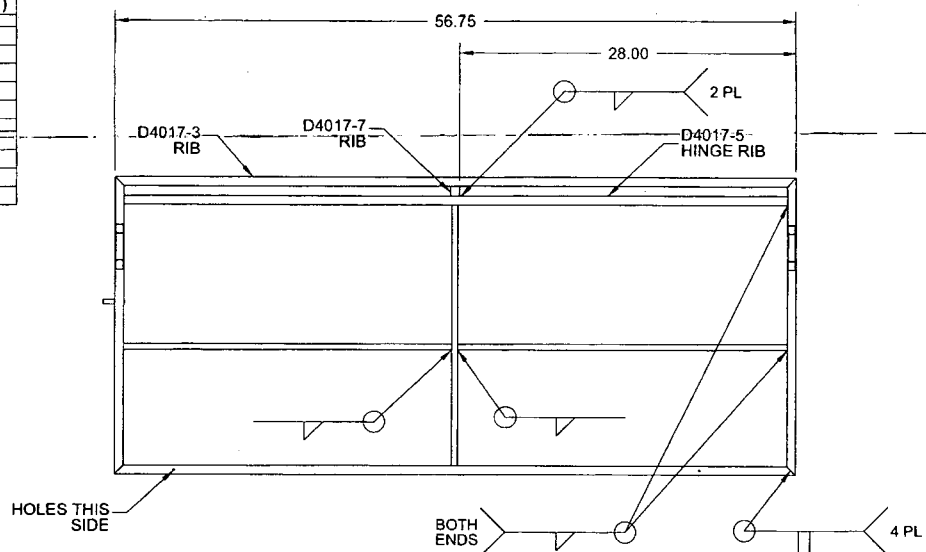


DETAIL D D1-3 B8-2

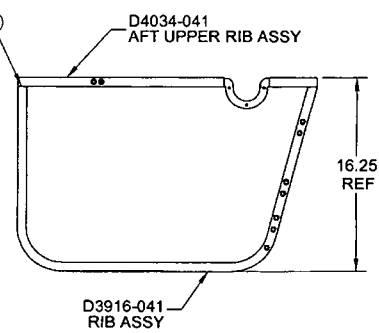
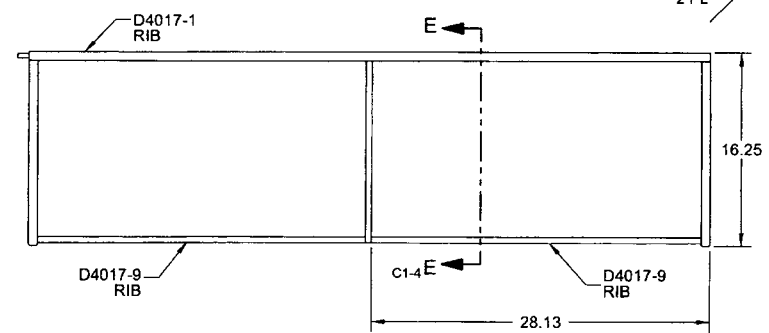
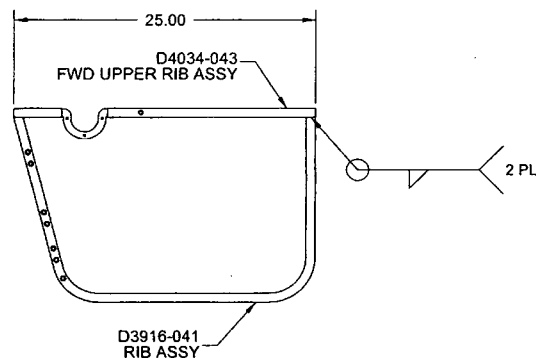
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DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 3 OF 5
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	SHORT-BASKET-BASE ASSY (350) -NTS	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 15.26 lbs  
8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101  
9) WELD PER DART QSI 004

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO. D4017	REV. C
MFG. APPR.	SYS. D.I.L.		SHEET 4 OF 5
APPROVED	JM	TITLE	SCALE
DE APPR.	JM	SHORT BASKET-BASE ASSY (350)	NTS
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